•	"r			
Work	Or	der	ID	57160



Page 1

Document Control

March 24, 2010	8:44:05 AM									
Item ID:	D206-642-341		Accept				S	Setup St	art    <b>    </b>	
Revision ID:								0.		
Item Name:	Replacement Skidtube							Si	top	
Start Date:	24/03/2010 Start Qty: 1.00			Cust Item I	D:					
Required Date	: 07/04/2010 Req'd Qty: 1.00			Customer:						
Reference:										
Approvals:	Process Plan:	Date/0-3-2-4	/ Tooling:	Da	ate:		F		art	
	QC:	Date:	<b>SPC (Y/N):</b>	Da	ate:			31	top	
Sequence ID/ Work Center I	Operation D Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		•							
D2650	F									
100	DOCUMENT CONTROL	<u>.</u>	0.00				NA	H	}	
DC	Memo		0.00					- <i>(-)</i>	<u> </u>	<del></del>

0.00

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

_										1.	»
	rospace	Ltd							•	•	<u> </u>
W/O:	1			WC	ORK ORDER CH	ANGES	· · · · · · · · · · · · · · · · · · ·		T	·	1
DATE	STEP		PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
		!									
	<del>  </del>										
			<u> </u>								
Part No	):	P	AR #:	Fault Cate	gory:	NC	R: Yes	No <b>DQ</b>	A:	_ Date: _	
			1		n:						
NCR:				WORK ORD	ER NON-CONFO	PRMANCE	E (NCI	₹)			
D.4.T.E.	0755	Description	of NC		<b>Corrective Action</b>	Section B		Verific	cation	Approval	Approv
DATE	STEP	Section		Initial Chief Eng	Action Descrip Chief Eng	otion	Sign of Date	& Secti	on C	Chief Eng	QC Inspec
											-
			!								
ts											
			<del></del>								
			1								
			;								

* * • • •		ACI II	
March.	24. 201	0 8:44:	05 AM
will, Cit	47, ZVI	0.44.	UJ MW

]	tem	ID:	

D206-642-341

Accept



Setup Start



Revision ID:

**Item Name:** 

Replacement Skidtube

**Start Date:** 

24/03/2010

Start Otv: 1.00

**Required Date:** 07/04/2010 Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

	_	
Approvals:	Process Plan:	

Date:

Tooling:

0.00

Date:

Run Start



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

Stop



Sequence ID/ Work Center ID

110



Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours** 

Draw Number

Draw Plan Rev. Code

Accept Oty

10"-3-30

Reject Qty

Reject Insp. Number Stamp

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R - Aluminum Rod - 1/2507 m113207

BE 10-3-30

4-Grind weld flush to cap on top surface only.

BE 10-3-30 5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

W/O:		WORK ORDER CHANGE						ES							
DATE	STEP		PROC	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	:														
•	·							<del>-</del>							
											·				
Part No:		P	AR #:	Fault Ca	tegory:	NC	R: Yes I	No DQA	\:	_ Date: _					
	R	esolution:	Disposition:				: N/C Clo	sed:		Date:					
NCR:			W	ORK OR	DER NON-CON	IFORMANCI	E (NCR)	)							
DATE	STEP	- Description	of NC Corrective Action Section B		Verification		Approval	Approval							
	SILF	Section	A 	Initial Chief Eng	Action Des	scription Eng	Sign & Date	Section		Chief Eng	QC inspector				
			  -  -												
									,						
·			! !						•		,				
,															
<b>B</b> ≤ ,															
		>	· · · · · · · · · · · · · · · · · · ·							*					
	30														

1	- 1	A BP					
<b>XX</b> /~	- 10			· ='	71	~	n
Worl	(31)	rau	erani	, D	71	o	U
				_	-	•	_



Page 3

March 24, 2010 8:44:05 AM D206-642-341 Accept Setup Start Revision ID: Stop Item Name: Replacement Skidtube **Start Date:** 24/03/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 07/04/2010 **Req'd Qty:** 1.00 **Customer:** Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop \_\_\_\_\_ Date:\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Work Center ID Operation Plan Set Up/ Draw Draw Reject Reject Accept Insp. **Description** Number **Run Hours** Number Rev. Code Qty Qty Stamp Chemical Conversion Coat per QSI005 4.1 0.00 H(2/3/3/ 0.00 Memo Hand Finishing 0.00 Skidtubes 0.00 Skidtubes 1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs Start Date: (2/4)  $\bigcirc$  Time:  $\bigcirc$  (3/4)  $\bigcirc$  Time:  $\bigcirc$  (3/4)  $\bigcirc$  Time:  $\bigcirc$  (3/4)  $\bigcirc$  Time:  $\bigcirc$  (3/4)  $\bigcirc$  Sikaflex expiry date:  $\bigcirc$ cure time before cutting AWM 10-3-31

Dart Aerospa	ce Ltd
--------------	--------

W/O:			ES			4	4.						
DATE	STEP		PRO	PROCEDURE CHANGE B				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		i							·				
Part No	•	P	AR #:	Fault Ca	tegory:	NCR: Yes	No <b>DQ</b>	A:	Date:				
	R	esolution:	Disposition:				QA: N/C Closed: Date:						
NCR:			·W	VORK OR	DER NON-CONFORMA	NCE (NCI	R)						
DATE	STEP	Description		NC Corrective Action			Verific	ation	Approval	Approval			
		Section /	<del>\</del>	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector			
				. `						-			
							:						
	•												
			,										

Page 4

March 24, 2010 8:44:05 AM

D206-642-341

Accept



Setup Start

Stop

Stop



**Revision ID:** 

**Item Name:** 

Replacement Skidtube

**Start Date:** 

24/03/2010

Start Qty: 1.00

**Required Date:** 07/04/2010 Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Rev.

Start Run



QC: \_\_\_\_\_ Date: \_\_\_\_

**SPC (Y/N):** 

Draw

Number

Draw Plan

Code

Accept

Reject

Insp.

Sequence ID/ **Work Center ID** 

140



QC

Quality Control

**Operation** Description

Skidtubes

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

0.00

Date:

Qty

Reject Number Stamp Qty

150

Skidtubes Skidtubes

Memo

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

0.00

0.00

A/R□□Aluminum Rod□ <u>M11260</u>7

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

4- Install nut plate as per dwg

10-4-6

W/O:			,	V	ORK ORDER CHANG	ES			1	
DATE	STEP		PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·		1100 11191	
	c									
		ļ	•							
Part No:P		AR #:	_ Fault Ca	tegory:	NCR: Yes No DQA: Date:					
Resolution:				_ Disposit	ion:	_ QA: N/C C	losed:		Date: _	
NCR:			W	ORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description	of NC		Corrective Action Section		Verific	ation	Approval	Approvai
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector	
			 							-
			<u> </u>							
			<u> </u>							
			1.							
					` 				-	
			į							



Page 5

March 24, 2010 8:44:05 AM

Item	ID:
nem	ıv:

D206-642-341

Accept



Setup Start

Stop



**Revision ID:** 

Replacement Skidtube Item Name:

**Start Date:** 

24/03/2010 Start Qty: 1.00

Required Date: 07/04/2010 Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

**Tooling:** 

0.00

Date:

Run Start



Date:\_\_\_\_\_

**SPC (Y/N):** 

Date:

Stop



Sequence ID/ **Work Center ID** 

160



HandFinish Hand Finishing Operation Description Set Up/ Run Hours Draw

Draw Number Rev.

Plan Code Accept Qty

Reject Reject **Qty** 

Insp. Number Stamp

HandFinishing

0.00

Install D2680-041 Nut Plate as per Dwg D2650

NIA done on say #150 DP10-4-6

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

Memo



Quality Control

OC5- Inspect part completeness to step on W/O

<b>Dart Aerospace</b>	Ltd
-----------------------	-----

	•									•	
W/O:			WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·						·					
		AR #:	R #: NCR: Yes No DQA:					_ Date: _			
Resolution:											
NCR:			1	WORK OR	DER NON-CONF	ORMANCE	(NCR	)	-		
DATE	STEP	Description	of NC			Section B			ation	Approval	Approval
		Section A	4	Initial Chief Eng	Action Descri	ption	Sign & Date	Section		Chief Eng	QC Inspector
			1								-
			!		• •						
			! !								
					_						
•			1		•						
			<u> </u> 						•		

March 24, 2010 8:44:05 AM

Item ID:

D206-642-341

Accept

Setup Start



Stop

**Revision ID: Item Name:** 

Replacement Skidtube

**Start Date:** 

24/03/2010

Start Qty: 1.00

Req'd Qty: 1.00 **Required Date:** 07/04/2010



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run Start



Date: \_\_\_\_

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** 



HandFinish

Hand Finishing

Operation Description

Pressure Wash per QSI005 4.3

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Memo
Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

Memo
Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

Plan

200



Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

Memo

START TIME: 10:30 AM
OVEN TEMPERATURE: 3709FINISH TIME: 11:00 AM

0.00

0.00

0.00=) JU 10/04/07

210



Quality Control

QC3- Inspect Part Finish

Memo

0.00

D. A 10-4-20

0.00

<b>Dart</b>	<b>Aeros</b>	pace	Ltd
-------------	--------------	------	-----

	-	i .											
W/O:	ŀ	İ		V	VORK ORDER CHA	NGES				,	+		
DATE	STEP		PROCEDURE CHANGE			Ву	<i>,</i>	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		 	·										
•		AR #:	#: Fault Category: NCR: Yes No DQA:				<b>A</b> :	Date:					
Resolution:				Disposit	ion:	QA: N/0	C.Clos	sed:	-	_ Date: _			
NCR:			V	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description				Section B	Sign &		ation	Approval	Approval		
		Section A		Chief Eng	Action Description Chief Eng	on Si	ate	Section	on C	Chief Eng	QC Inspector		
			<u> </u> 								-		
							•		,				
					·								
			<u> </u> 								,		
			1										

# Work Order ID 57160

March 24, 2010 8:44:05 AM



Page 7

Item ID:

D206-642-341

Accept

Setup Start

Stop

Stop



**Revision ID:** 

**Item Name:** 

Replacement Skidtube

Start Date:

24/03/2010

Start Oty: 1.00

**Required Date:** 07/04/2010

Reg'd Oty: 1.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Process Plan:

Date: Tooling:

Date:

Draw

Rev.

Run

Approvals:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Plan

Code

Reject

**Qty** 

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

220



HandFinish Hand Finishing

HandFinishing

Operation

Description

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R□□Sikaflex-291

Sikaflex expiry date:□

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive A/R  $\square$  Sikaflex-291

Sikaflex expiry date:

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 \(\sigma\)

Accept

Qty

Bl 10-4-21

Dart Ae	rospace Lt	d								
W/O:			WC	RK ORDER CHANG	ES			, ,		
DATE	STEP	PR	OCEDURE CHAI	DURE CHANGE By			Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
·										
		Ì								
							<u> </u>			
Part No	Part No:PAR #:		Fault Category: NCR: Yes No DQA:				_ Date: _			
			Disposition	n:	_ QA: N/C Cld	osed:	Date: _			
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR	)				
5		Description of NC		Corrective Action Secti	on B	Verification	Ammunual			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
								-		
		ļ								
						·				
ļ										
		ı								

# Work Order ID 57160

March 24, 2010 8:44:05 AM

**Required Date:** 07/04/2010



Page 8

Item ID:

D206-642-341

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

24/03/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Approvals:

Reference:

Process Plan: Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** 

230



Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours** 

Number

Draw

Draw Plan Rev. Code

Accept Reject Otv Oty

Reject

Insp. Number Stamp

**Quality Control** 

Memo

Memo

1.4



Quality Control

QC5- Inspect part completeness to step on W/O

250



Packaging

Packaging

0.00

0.00

Memo Identify and pack for shipping as per PPP D206-642-341

PPP Rev:

PM 57194

Colopys cl

Dart	Aer	ospa	ce L	td
-	~~:	oobu	~~ _	

	•	-								
W/O:				W	ORK ORDER CHANG	ES				* *
DATE	STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		i								
Part No:		PA	R #:	Fault Cate	gory:	NCR: Yes	_ Date: _			
Resolution:			Disposition	n:	_ QA: N/C C	losed:		Date: _		
NCR:			,	WORK ORD	ER NON-CONFORMA	NCE (NC	R)	<u>.</u>		
DATE	STEP	Description of	of NC			Verifica			Approval	Approval
	O.L.	Section A		Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Secti	on C	Chief Eng	QC Inspector
				·						-
•										

# Work Order ID 57160

March 24, 2010 8:44:05 AM

**Required Date:** 07/04/2010



Page 9

Item ID:

D206-642-341

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

24/03/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference: Approvals:

Process Plan: \_\_\_\_\_ Date:

Tooling:

Date:

Run Start



Date:\_\_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

260

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp.

Quality Control

Memo

0.00

0.00

Number

Stamp

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

	•										
W/O:	/O:		WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	:										
			· .				<u> </u>				
					•		1				
Part No	•	PA	R #:	Fault Cat	egory:	NCR: Ye	s No DO	)A:	Date:		
					on:						
NCR:				WORK OR	DER NON-CONFORI	MANCE (NO	CR)		· · · · · · · · · · · · · · · · · · ·		
DATE	STED	Description of	Pescription of NC			ection B	Verif	ication	Approval	Approval	
	STEP Description of Section A	<u> </u>	Initial Chief Eng	Action Description Chief Eng	n Sig Da	1&r Sec	tion C	Chief Eng	QC Inspector		
			1							-	
_			į								
		,									
					· · · · · · · · · · · · · · · · · · ·		-				
			İ	1		1			1	·	

Picklist Print March 24, 2010 8:4	14:09 AM									Page
Work Order ID: 57  Parent Item: D2  Parent Item Name:  Comments:	Replacement Skidtu IPP Rev: H□05.10. IPP Rev:I 08-09-2	ļ	r CHG004□KJ/CP/JI DD verified by:EC	<b>                                    </b>			tart Date: 24/0		Required Date Required Qty	
Component Item ID/ AN960JD416	Replacement	Mfg/ Bin Purchased No	•	st Route	Unit of Each	<b>Qty on</b> 8.0000	Remaining	Qty	Date	Status
CCR264SS3-3  Cherry Rivet	NAS [149]	DO4635  Purchased No	Warehouse Location Main Warehous ST357	° 1137061	8 8 8 Each	Loc Code 513.0000	2.0000	,	BK 10-1	M-21.
CR3212-4-03 Cherry Rivet		Purchased No	Warehouse Location  Main Warehous  ST311  11154  11182 11231 11353	e .8 .7 4	513 16 1 2 6 488 Each	236.0000	2.0000	\( \)	10-4-6	2
			Warehouse Location Main Warehouse ST311 11135		236 84 152	Loc Code	D	) ,	10-4-6	7

Dart	Aerospace	Ltc
WIO.		

W/O:				V	ORK ORDER CHANG	GES					
DATE	STEP		PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Eng / Approval	
									. •		
Part No					tegory:						
	R	esolution:			ion:				Date: _		
NCR:			ļ V	VORK OR	DER NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of	f NC			tion B	Verific	ation	Approval	Approvai	
DAIL	SIEF	Section A	:	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector	
										-	
	I	i	1	1	İ				I	1	

# **Picklist Print**

March 24, 2010 8:44:09 AM

Page 2

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

Start Date: 24/03/2010

**Required Date:** 07/04/2010

Required Qty: 1.00

Component Item ID/

D2620

Replacement Mfg/ Manufactured

03-02 as per DSI9440 rev.a DD verified by:EC

No

Bin Primary

Last

Route

Unit of Each

Qty on 8.0000

Remaining 1.0000

Start Qty: 1.00

Qty

Date

Status

Skidtube, 206 Skidtube

Warehouse

Location

Main Warehouse



Loc Qty

1.0000

D2647

Cap

Warehouse

Loc Qty

Loc Code

87.0000

Location

Main Warehouse

FP

55352

87 87

Loc Qty

207

5

18

4

3

177

Each

207.0000 19.0000

BE 10-3.30

D2649

Cross Bolt Spacer

Manufactured

Manufactured

No

Warehouse Location

Main Warehouse LG 36013

> 47112 48271 51529 55000

Loc Code

19 BE 10/04/05

March 24, 2010 8:44:09 AM

**Shop Packet Print** 

Page 2

Dart Ae	rospace	Ltd							· ·		
W/O:				W	ORK ORDER CH	ANGES				5 <b>4</b>	Dec.
DATE	STEP		PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		,									
								· · · · · · · · · · · · · · · · · · ·			
Part No	):	PA	R #:	Fault Cat	egory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	
					on:						
NCR:			1	WORK ORE	DER NON-CONFO	RMANC	E (NCF	l)	11.00		
DATE	STEP	Description o	f NC		<b>Corrective Action</b>	Section B		Verific	ation	Approval	Approva
DATE	SIEP	Section A		Initial Chief Eng	Action Descrip Chief Eng		Sign 8 Date	Section		Chief Eng	QC Inspecto
										:	-
							,				

March 24, 2010 8:44:09 AM

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

D2680-041

ALS4-1032-130

Insert

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Purchased

No



Start Date: 24/03/2010

Start Qty: 1.00

Required Date: 07/04/2010

Required Oty: 1.00

Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Oty on Remaining Qty Date D2654-5 Status Manufactured No Each 2.0000 1.0000 Web

> Warehouse Loc Oty Loc Code Location Main Warehouse LG 2 Manufactured Each. . 51.0000 1.0000

Nut Plate

Warehouse Location

Main Warehouse ST021

220

Loc Code

51 50 Each

Loc Code

Loc Qty

438.0000 54.0000

Warehouse Loc Oty Location

Main Warehouse

ST282 //N/407

110511

438 438

54. Bl/0-4-21

# **Dart Aerospace Ltd**

	-									
W/O:				W	ORK ORDER CHAI	NGES				
DATE	STEP		PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PA	R #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	•				on:					
NCR:			,	WORK ORI	DER NON-CONFOR	MANCE (NC	R)			
DATE	STEP Description of NC Co					————— Verification ∣ An				
DAIL	STEP	Section A		Initial Chief Eng	Action Description Chief Eng	on Sign Date	& Secti	on C	Chief Eng	Approval QC Inspector
		: !							- -	-
				\						
···										
					. 1					
		;								
								,		

March 24, 2010 8:44:09 AM

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DS19440 rev.a DD verified by:EC



Start Date: 24/03/2010

Start Qty: 1.00

**Required Date:** 07/04/2010

Required Qty: 1.00

Component Item ID/ Replacem AN960C10L	ent Mfg/ Purchased	Bin No	Primary	Last	Route 220	Unit of Each	<b>Qty on</b> 0.0000	Remaining 54.0000	Qty	Date	Status
	T di chiasca		NA	5 114	4C0332	_			524	. bl. 10	-4-21.

Washer

AN960JD10L

Purchased

Manufactured

No

No

220

Each

3,003.000 2.0000

Warehouse Loc Oty Location Main Warehouse ST348 3003 101291 16

105793 49 110985 2938

220 Each 41.0000 1.0000  a Bil 10-4-21

D2646

Aft Cap

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
FP6	36	
46327	4	
48109	4	
52663	28	
Main Warehouse		
fp7	5	

5

John 10-4-21.

52663

	rospace Lt		****								,
W/O:				W	ORK ORDER CHA	NGES			-		
DATE	STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No				Fault Cate	egory:						
	neso	iution:			on:					Date: _	
NCR:				WORK ORE	ER NON-CONFOR	RMANCI	E (NCF	₹)			
DATE	OTED	Description o	of NC		Corrective Action	Section B		Verifi	cation	Approval	Annrovo
DATE	STEP	Section A		Initial Chief Eng	Action Description Chief Eng	on	Sign a	& Sect	ion C	Chief Eng	Approva QC Inspecto
											-
	1	'	'				1	1			Į
			ı 								

March 24, 2010 8:44:09 AM

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:  $H \square 05.10.11 \square$  Added D3429-1 per CHG004 $\square$ KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

**Start Date: 24/03/2010** 

**Required Date:** 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2651-1	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 220	Unit of Each	<b>Qty on</b> 348.0000	Remaining 14.0000	Qty	Date	Status
				Warehou Loca		Loc	<u>Oty</u>	Loc Code				

Warehouse	Loc Oty	Loc Code	
Location		1	
Main Warehouse		(	·
FP	141		- BR 10-4-21
51530	141	/	H, BK 10-4-31
Main Warehouse			
fpa	207		
53349	207		•
	220 Each	537.0000 14.0000	
		1 (200) (100)	

D2651-3 O-Ring

Manufactured



Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		ŀ
FP	537	•
43849	3	
43849 46114	534	

# BK 10-4-21.

-				,		<del></del>				
Dart Ae	rospace	Ltd								
W/O:				WO	RK ORDER CHANG	ES		——————————————————————————————————————	<i>t</i> : •	
DATE	STEP		PR	OCEDURE CHAI		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	P/	\R #:	Fault Cated	jory:	NCR: Yes	No DOA:	Date:		
						QA: N/C Closed: Date:				
NCR:			1	WORK ORDE	R NON-CONFORMA	ANCE (NCR	)	1		
DATE	CTED	Description	of NC		Corrective Action Sect	ion B	Verification	Ammercal	Anneced	
DATE	STEP	Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
•									-	

		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
								-
	'							
					,			
					:			
NOTE		1 - 11 1						

March 24, 2010 8:44:09 AM

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev: H $\square$ 05.10.11 $\square$ Added D3429-1 per CHG004 $\square$ KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Manufactured

Manufactured



Start Date: 24/03/2010

**Required Date:** 07/04/2010

Start Qty: 1.00 Required Qty: 1.00

Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date D3536-11 Status Manufactured No 220 Each 14.0000 1.0000

Gasket

	Warehouse Location	<u>Lo</u>	c Oty	Loc Code			٠,١
	Main Warehouse						-
	ST497A		14				1
	46649		10			1 - DK 10-H-21	1
	46715	•	4				;
No		220	Each	8.0000	1.0000		
						3	1

D3536-23

Gasket

Warehouse	Loc Qt	<b>y</b> .	Loc Code	
<b>Location</b>				
Main Warehouse				
FP		8		
30754 53468		1	ř	
53468 t		7		
2	220	Each	11.0000	1.0000

Gasket

D3536-35

<u>Warehouse</u>	Loc Oty	Loc Code
<u>Location</u>		
Main Warehouse		
FP /	11	
51628	11	

- Bl 10-4-21.

1 BR 10-4-21

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

W/O:			WORK ORDER CHANGES									
DATE	STEP		PR	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		-						,,				
								•				
			<del></del>									
		; ;						•				
Part No	•	PA	R #:	Fault Ca	tegory:	NCI	R: Yes	No <b>DQ</b> /	<b>A</b> :	Date:		
					ion:							
NCR:				WORK OR	DER NON-CONFO	RMANCE	(NCR	)		_		
DATE	STED	Description of	of NC	Corrective Action Section B			Verificat			Approval	Approval	
DATE	STEP Description Section A			Initial Chief Eng			Sign & Date	Section C		Chief Eng	QC Inspector	
											-	
				·								
						į						
									*			

## Picklist Print

March 24, 2010 8:44:09 AM

Page 8

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Manufactured

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date D3537-1 Status Manufactured No 220 Each 53.0000 6.0000 Wearpad

Warehouse Loc Qty Loc Code Location Main Warehouse 52 2 55465 50 Main Warehouse

FP17 51678

220

24.0000 1.0000

D3537-3 Wearpad

Warehouse

Loc Oty

1

Each

Loc Code

Location Main Warehouse

24 4 35697 20 \$ pl 15-4-21,

6 pt 13-4-21

Dart Ae	rospace Li	td							,		
W/O:				WO	RK ORDER CH	IANGES					, ,
DATE	STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAF									
NCR:			1	WORK ORDE	R NON-CONFO	DRMANCE	(NCR	)			
DATE	STEP Description Section		I OI NC		Corrective Action Section Action Description Chief Eng		Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
											-

DATE	OTED	Description of NC		Officers Action Section B	Verification	Approval	Annroval	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	Approval QC Inspector
								-
				·				
								}.
					i	1	ł	1 1

#### Picklist Print

March 24, 2010 8:44:09 AM

Page 9

Work Order ID: 57160

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

**Required Date: 07/04/2010** 

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ MS27039-1-08

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 220

Unit of

Each

Each

Qty on Remaining 2,105.000 56.0000

Qty

Date

Status

Screw

Warehouse Loc Qty Loc Code Location Main Warehouse ST291 2105 110467 3 110552 102 110835 2000

MS27039-4-06

Screw

Purchased

No

220

38.0000 1.0000

Warehouse Loc Qty Loc Code Location Main Warehouse ST292 38 10906k 38

I Bl 10-4-21.

56. Bl 10-4-21

Dart Ae	rospa	ce Ltd
---------	-------	--------

		l l									
W/O:		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE				,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				<u>.</u>							
,											
					· · · · · · · · · · · · · · · · · · ·			· · · · · · · · · · · · · · · · · · ·			
Part No	•	PA	R #:	Fault Ca	tegory:	NCR: Y	es N	o <b>DQ</b>	<b>A</b> :	_ Date: _	
	Re	solution:		Disposit	ion:	QA: N/0	Clos	sed:		Date:	
NCR:				WORK OR	DER NON-CONFORM	MANCE (N	CR)				
DATE	STEP	Description of				ection B	V			Approval	Approval
		Section A		Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector
		•									_
							_				
			ı								

QTY QTY QTY PART NUMBER DESCRIPTION D2650-1 SKIDTUBE ASSEMBLY Х D2650-3 SKIDTUBE ASSEMBLY D2650-5 SKIDTUBE ASSEMBLY Х D2650-7 SKIDTUBE ASSEMBLY D2600-1-160 EXTRUSION D2654-1 WEB D2654-3 WEB D2654-5 WEB D2654-7 WEB D2646 AFT CAP 1 1 D2647 CAP 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 14 22 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING D2680-041 **NUT PLATE** 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 44 54 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) 2 2 AN960JD10L WASHER CCR264SS3-3 RIVET 2 2 2 2 2 2 2 2 CR3212-4-03 RIVET 2 2 2 2 MS27039-1-08 SCREW 1 1 MS27039-4-06 SCREW AN960JD416 WASHER 1 52 CR3212-4-04 RIVET

SHEDIPCIONY REFIGURALIA) ENGINISTRIVE UNCONTROLITY SUBJECT TO AMENDMENT WITHOUT WITH'E WORK ORDER NO. 52160 BS 10-3-24

NOTES:

D

1) MATERIAL: N/A

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART OSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:

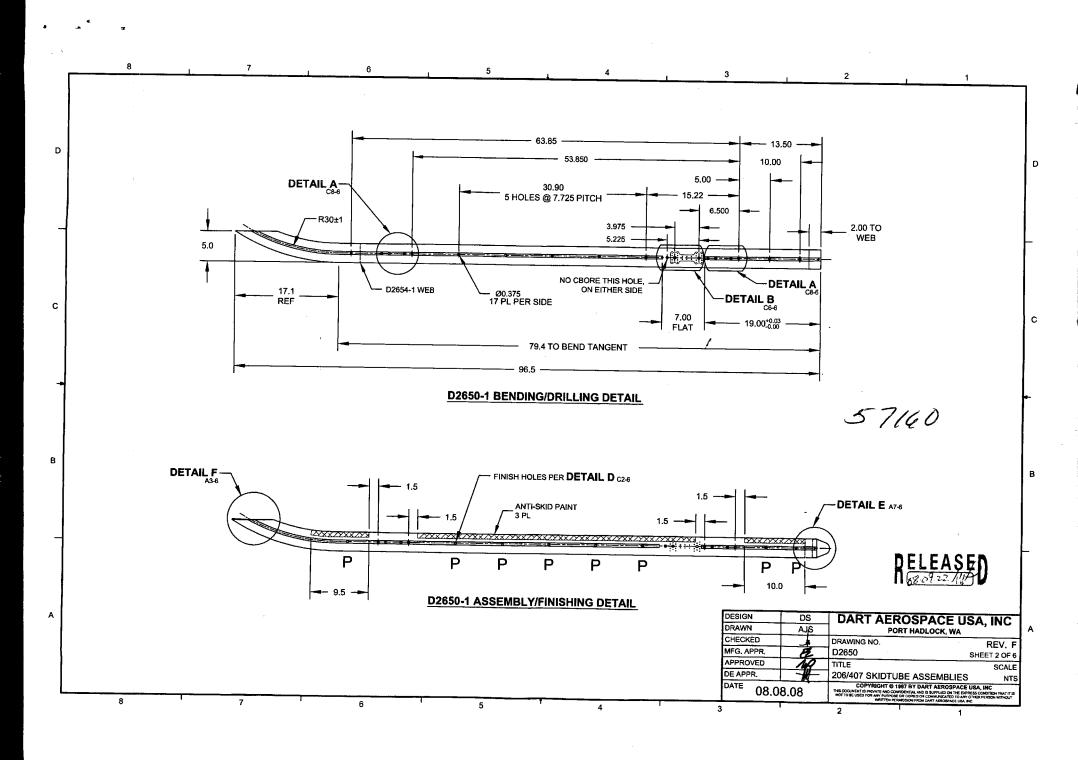
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

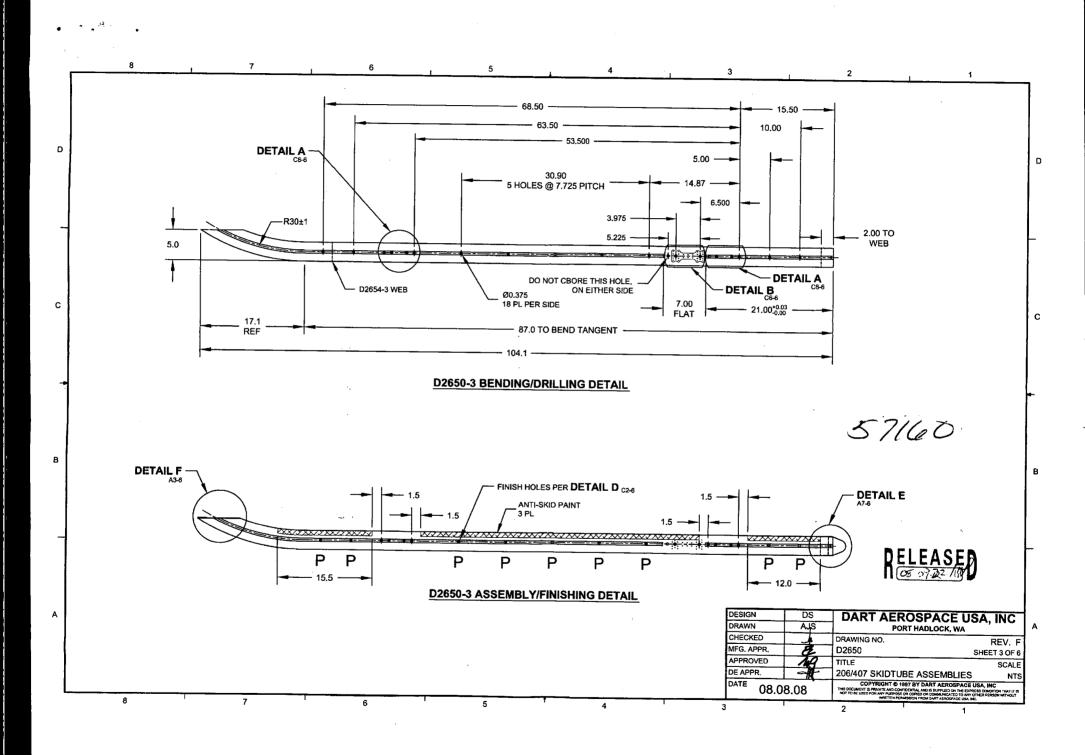
DESIGN	DS DADT AFPOSDAC		A INC
REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	DS	97.03.25
В	AS MANUFACTURED CHANGES	DS	97.06.26
С	CHANGE HOLE PATTERN AND FRONT END	DŞ	97.10.29
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6, SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08

DECICITY DO		UMANI MERUSPACE US	A. INC
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	8	D2650 s	HEET 1 OF 6
APPROVED	160	TITLE	SCALE
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE 08.0	80.80	COPYRIGHT © 1997 BY DART AEROSPACE US THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND BE BUPFLED ON THE EXPRES HOT ORE MEDITOR MAY PRIVATE OF COMPANY OF THE AND THE	S CONDITION THAT IT IS

W/O:				WO	RK ORDER CHANGES	}	***************************************		<del>,</del>
DATE	STEP		PR	OCEDURE CHAN	****	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	):	P	\R #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
	Reso	lution:		Disposition	•	QA: N/C CI	osed:	Date: _	<del></del>
NCR:				WORK OPDE	D NON CONFORMAN				
		'		WORK ORDE	R NON-CONFORMAN	CE (NCF	<b>(1)</b>		
DATE	CTED	Description of			Corrective Action Section I	3	Verification	Annroyal	Approva
DATE	STEP	<b>Description</b> of Section A	of NC			-	Verification	Approval Chief Eng	
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		Approva QC Inspecto
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		
DATE	STEP		of NC	Initial	Corrective Action Section I Action Description	Sign 8	- Verification		

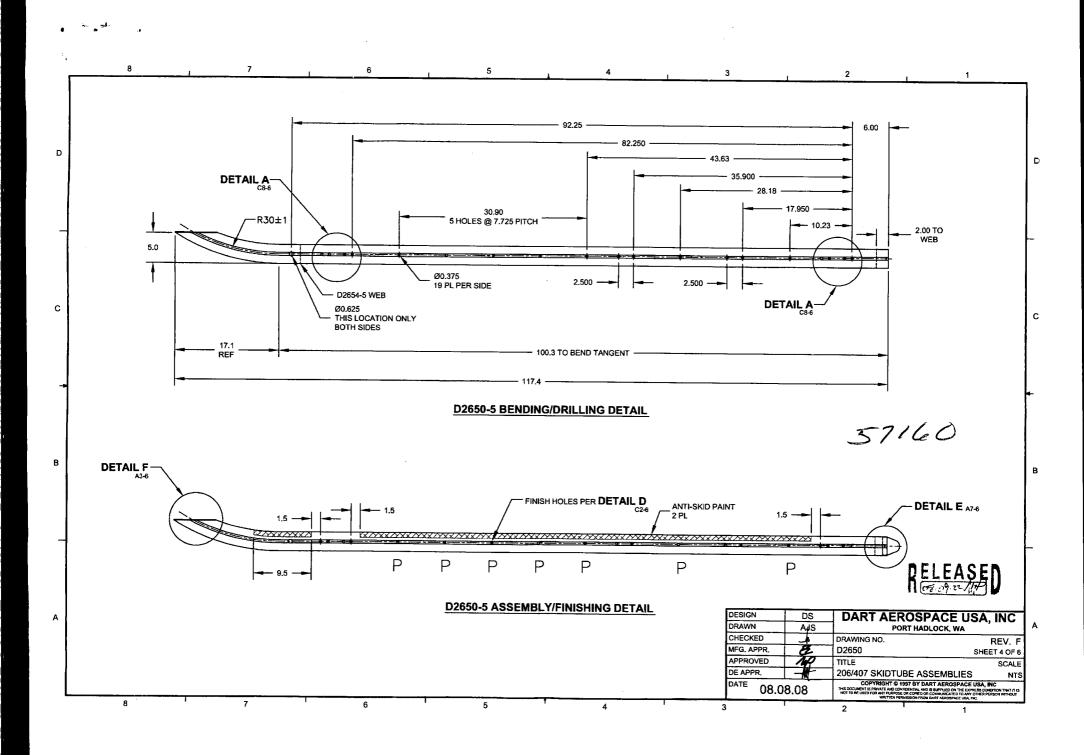


	•									
W/O:		WORK ORDER CHANGES								• •
DATE	STEP		PR	OCEDURE CHAI	NGE /	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAI	R #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date:	
	Reso	olution: Disposition:			l <b>:</b>	QA: N/C Closed: Date				
NCR:			,	WORK ORDE	R NON-CONFORM	ANCE (NCF	₹)	<del></del>		<u> </u>
DATE	STEP	Description o							Approval	Approval
		Section A		Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector
		:								-
										-
		,								
		ļ								
								*		

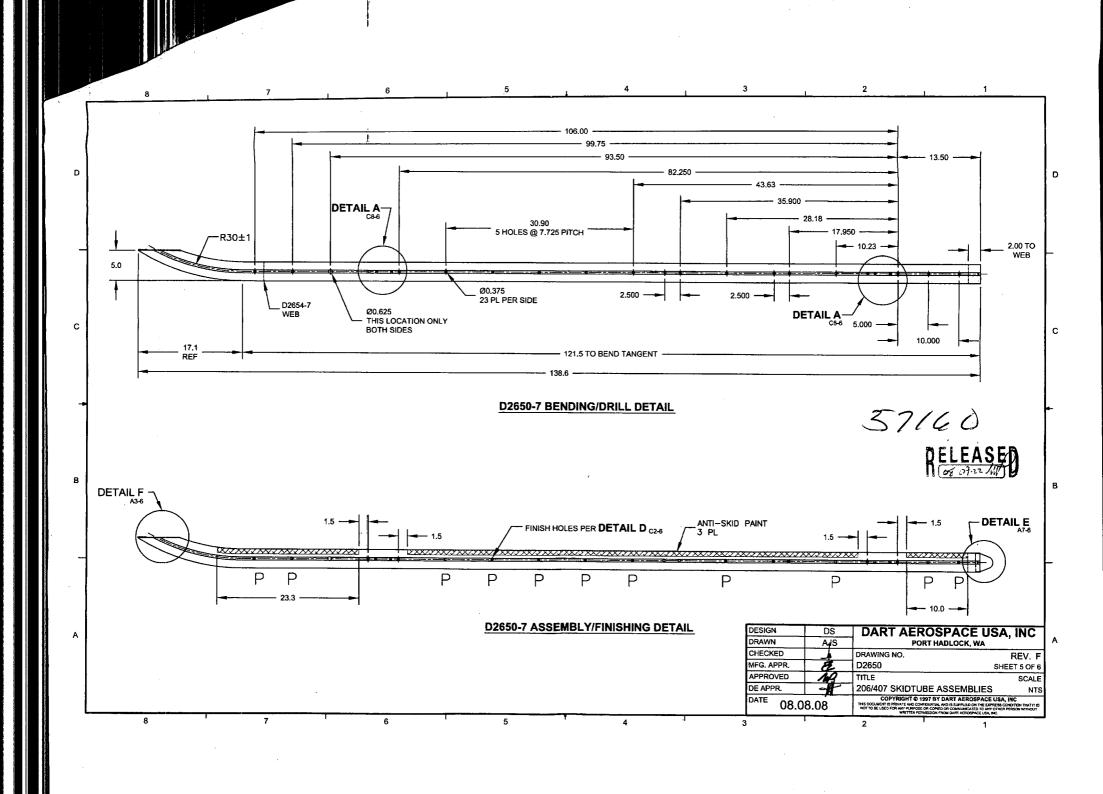


Dart Aero	space	Ltd
-----------	-------	-----

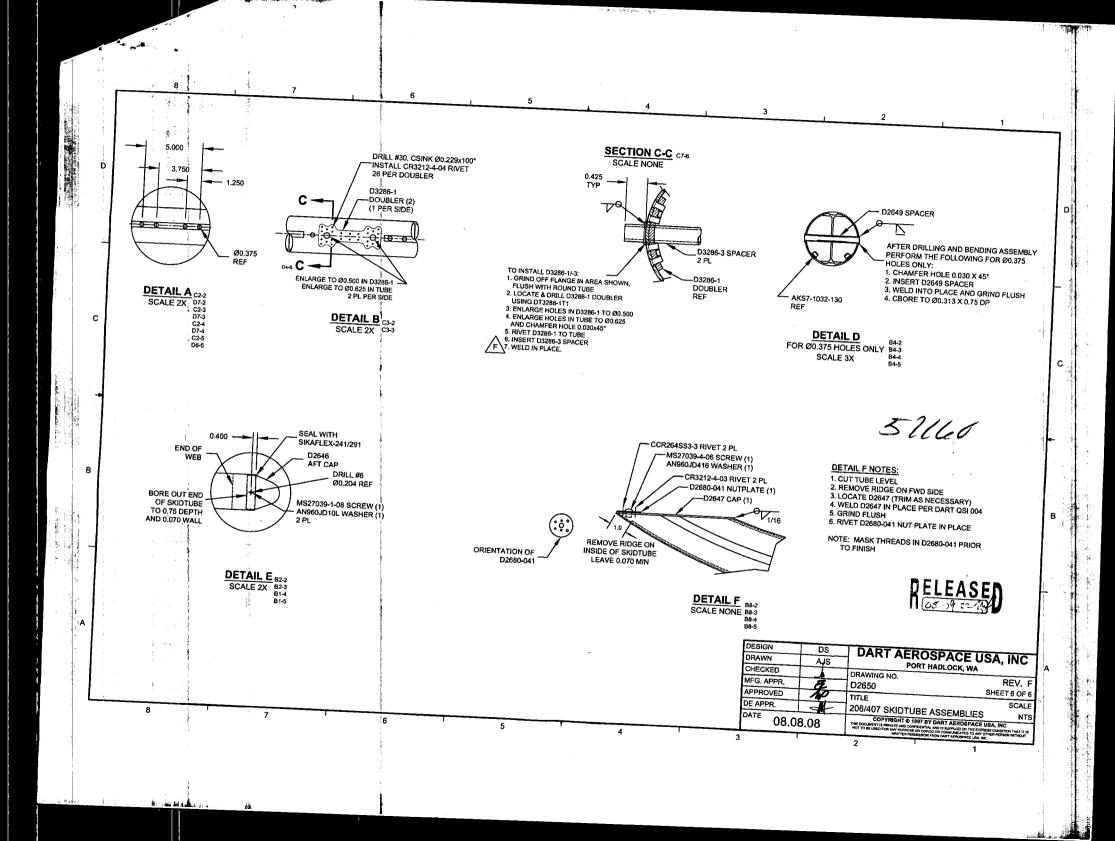
	•										
W/O:			WORK ORDER CHAN								,
DATE	STEP		PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PA	R #:	_ Fault Ca	tegory:	NC	R: Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date:	
							QA: N/C Closed: Date:				
NCR:		·	W	ORK OR	DER NON-CONFO	DRMANCE	(NCR)				
DATE	STEP	Description o	f NC	Corrective Action Section B			Verification   Ar			Approval	Approval
	0.2.	Section A	i	initial Chief Eng	Action Descri Chief Eng	ption 	Sign & Date	Section	on C	Chief Eng	QC Inspector
											-
,											
		·									
		·									



Dart Ae W/O:			\MC	RK ORDER CHANG	E0			1	
DATE	STEP	PR	OCEDURE CHAI		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			<del>.</del>						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	<b>A</b> :	Date:	
	Reso	lution:	Disposition	າ:	QA: N/C C	osed:		Date: _	
NCR:		!	WORK ORD	ER NON-CONFORMA	NCE (NCF	?)			*****
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Sect	ion C	Chief Eng	QC Inspect
									-
					l	1			
		ļ 							



Dart Aer	rospace Lte	•								
W/O:			WO	RK ORDER CHAN	GES	,		$\overline{}$		
DATE	STEP	PRO	PROCEDURE CHANGE			у	Date	Qty	Cr. Proo	* 0
Part No		PAR #:								
	Reso	lution:	Disposition	QA: N	QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORM	MANCE (I	VCR)	)			
DATE	STEP	Description of NC		Corrective Action Se	ection B		Verifi	ication	Approval	Approva
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		tion C	Chief Eng	QC Inspecto
										-
ļ										



	ospace Ltd									
W/O:				WO	RK ORDER CHANG	ES	•			
DATE	STEP		PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Ap) QC Insp.
Part No:		P	AR #:	Fault Categ	ory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	
						osed: Date:				
NCR:					R NON-CONFORM					
DATE	0750	Description	of NC		Corrective Action Sect	ion B	Verific	ation	Annua	
DATE	STEP	Section	Α	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Approval Chief Eng	Approv QC Inspec
:										-
ı										
	·									
				`					1	1

NO. 223

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Carday Filloff	
The state of the s	
rait number: 0001	_
- cochiption.	
	_
Dase materiel:	
Current: AC DC[ ]	

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration: <u>UNACCEPTABLE</u>	pass[ /] fail[ ] pass[ /] fail[ ]
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[ ] fail[ ] pass[ ] fail[ ] pass[ ] fail[ ] pass[ ] fail[ ] pass[ ] fail[ ] pass[ ] fail[ ]
Qualifier fat. Sal.  Welder Dorchallied  The above named individual is qualified.	Date of Test Coupon 10.02.16  Date of Test Coupon 10-02-16